



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2807-041
Job Sheet 175656

DAS
21
9-89



Part No: D2807-041

Job Qty: 14 ea *split*

Part Name: Prop Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/17/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV E IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	14 pcs		4/16/18	0.00	0.00	Purchasing		<i>AT 19/07/19</i>
110	Packaging	14 pcs		4/16/18	0.00	0.00	Packaging2		<i>AT 19/07/19</i>
120	QC	14 pcs		4/16/18	0.00	0.00	QC6		<i>APR 19 2018</i>
130	Small Fab	14 pcs		4/17/18	0.00	0.27	Small Fab-2		<i>8-89 DAS 38</i>
140	QC	14 pcs		4/17/18	0.00	0.00	QC5		<i>8-89 DAS 38</i>
150	Packaging	14 pcs		4/17/18	0.00	0.00	Packaging3-1	<i>ST-011</i>	<i>APR 18-6-13</i>
160	QC21-SA	14 Ea		4/17/18	0.00	0.00	QC21		<i>DAS 21 18-06-14</i>

Part Op 100 - Issue P/O: *39552* Order as per Dwg D2807 Possible supplier: Lift Support

Descriptions: Technologies, Saskatoon, Canada P/N 6/15-164/50-115N

110 - Ensure Material Release Note is attached

130 - 1-install D3671-1 as per dwg D2807

APR 13 2018

DAS
13
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3671-1	Placard	14 Ea (1 ea)	100-Purchasing	
6/15-164/50-115N	Gas Spring D2807-041	14 pcs (1 ea)	130-Small Fab	<i>5046319 9x</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D3671-1	14	9	0
130-Small Fab	6/15-164/50-115N	14	0	0

Part Specifications

Specifications could not be found.

Plex 4/13/18 8:35 AM dart.lavoie.chantal



Container No: **S062966**



Prop Assembly

PART NO: **D2807 - 041**

Serial No/Batch: **S062966**

Revision:

Operation:

Change No:

Packaging

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 04/19/18
Job No: 175656

SPECIFICATION CONTROL DRAWING

(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS

ARROW POINTS OUTBOARD
ARROW POINTS OUTBOARD

4.88
COMPRESSED

6.46
EXTENDED

D2807-041 GAS SPRING

RELEASED

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

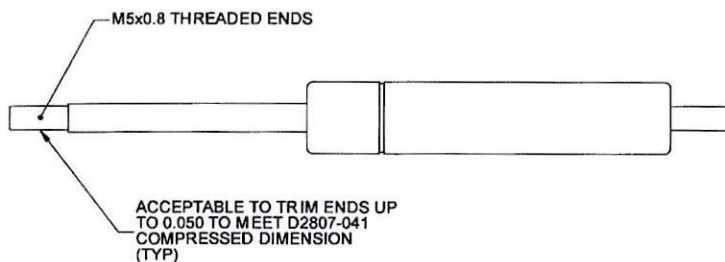
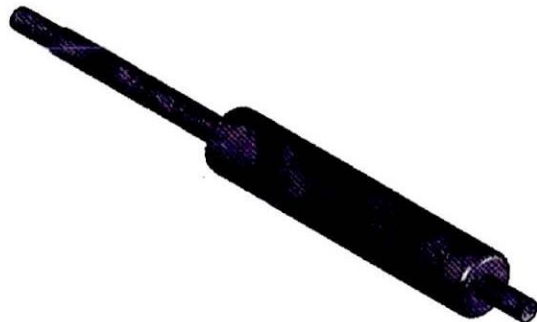
QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

E

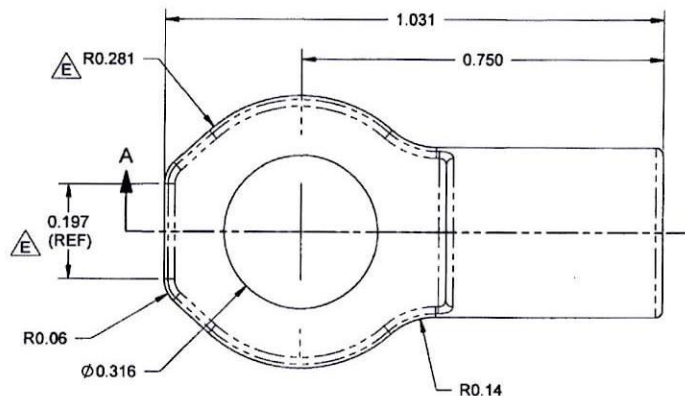
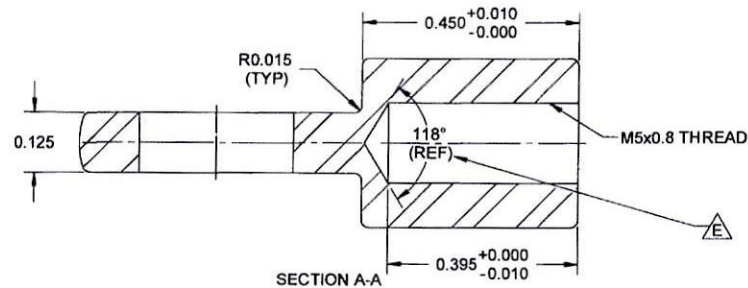
E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	MP	D2807	SHEET 1 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	GAS SPRING	NTS
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

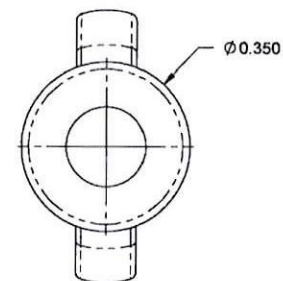
- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



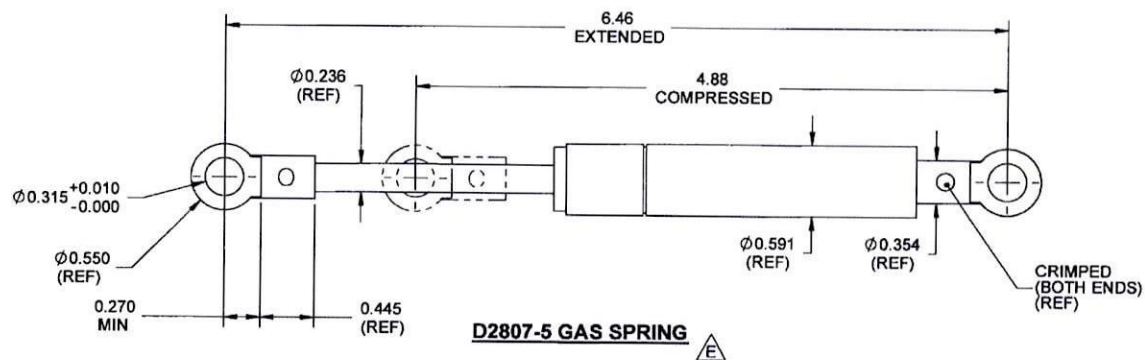
D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.		D2807	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING	4:1
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D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA
(P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS,
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.	MP	D2807	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	GAS SPRING	4:1
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039552**

Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

PO No: PO039552

PO Date: 4/10/18

Due Date: 4/17/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

E-MAILED
APR 13 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

REVISED

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	6/15-164/50-115N			Gas Spring D2807-041 As per Dwg D2807 Rev. E	Firmed	4/17/18	14 pcs	0 pcs	14 pcs	\$68.37/pcs	\$957.18
<i>14x</i>											
Line Item Note job no. 175656											
2	B8-154-382-050N			Gas Spring D5479-1 As Per Dwg D5479 Rev. A	Firmed	4/17/18	12 pcs	0 pcs	12 pcs	\$38.90/pcs	\$466.80
<i>12x</i>											
Line Item Note job no. 175648											

Grand Total: \$1,423.98

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 4/13/18 8:33 AM dart.lavoie.chantal



LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

April 13, 2018

This is to certify that the parts listed below meets specifications as required by your order.

14 Units : D2807-041 #175656 Stainless Gas Spring

12 Units : D5479-1 #175648 Gas Spring (B8-154-382-050N)

Country of Manufacture: Canada
Date of Manufacture : April 2018
This product is ROHS compliant.

Purchase Order # 039552
Invoice # 18248

L S Technologies Inc Canada

Nolan Fehr
President